

SPLIT


DART AEROSPACE LTD		Work Order:	22248
Description: Frame Weldment		Part Number:	D3330-041
Dwg: D3330 Rev. A PAGE 1		Qty:	5
RF 05.01.12		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																				
1	DC	Issue Traveler	JA	05.01.17	16																																																				
2	MFA	Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr><td>1</td><td>D3330-1</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-2</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-3</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-5</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-7</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-9</td><td>Panel</td><td>M16387</td></tr> <tr><td>1</td><td>D3330-11</td><td>Long Pin Bracket</td><td>B 22267 M16019 CPL</td></tr> <tr><td>1</td><td>D3330-13</td><td>Short Pin Bracket</td><td>B 22260 M16230 CPL</td></tr> <tr><td>1</td><td>D3330-15</td><td>Handle</td><td>B 22259 M16230 CPL</td></tr> <tr><td>1</td><td>D3330-17</td><td>Handle Socket</td><td>M15925 CPL</td></tr> <tr><td>1</td><td>D3330-19</td><td>Handle Rim</td><td>B 22262 M16332 CPL</td></tr> <tr><td></td><td></td><td></td><td>B 22263 M15990 CPL</td></tr> </tbody> </table> Identify as D3330-041	Qty	Part Number	Description	Batch	1	D3330-1	Panel	M16387	1	D3330-2	Panel	M16387	1	D3330-3	Panel	M16387	1	D3330-5	Panel	M16387	1	D3330-7	Panel	M16387	1	D3330-9	Panel	M16387	1	D3330-11	Long Pin Bracket	B 22267 M16019 CPL	1	D3330-13	Short Pin Bracket	B 22260 M16230 CPL	1	D3330-15	Handle	B 22259 M16230 CPL	1	D3330-17	Handle Socket	M15925 CPL	1	D3330-19	Handle Rim	B 22262 M16332 CPL				B 22263 M15990 CPL	CPL	05-01-18	5
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3	QC5	Inspect work to Step 2	JA	05.02.15	5																																																				
4	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	M	05.02.24	5																																																				
5	QC3	Inspect Powder Coat	CL	05/02/24	5																																																				
6	ST	Identify and Stock	CL	05/02/24	5																																																				
7	AC	Cost/Part: 48.01	Syc	05.02.25	5																																																				
8	DC	Close W/O 48.00 Inspect Level 21	JA	05.03.02	5																																																				

Rev	Date	Change	Revised By	Approved
A	05.01.13	New Issue	KJ/JLM	

PTD
9 ←

RELEASED
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.02.15	1	D 3330-1/-3/-5/-7 USE FOR TEMPLATE	RF	05.02.18	1 ea	RF 05.02.15	 050302

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

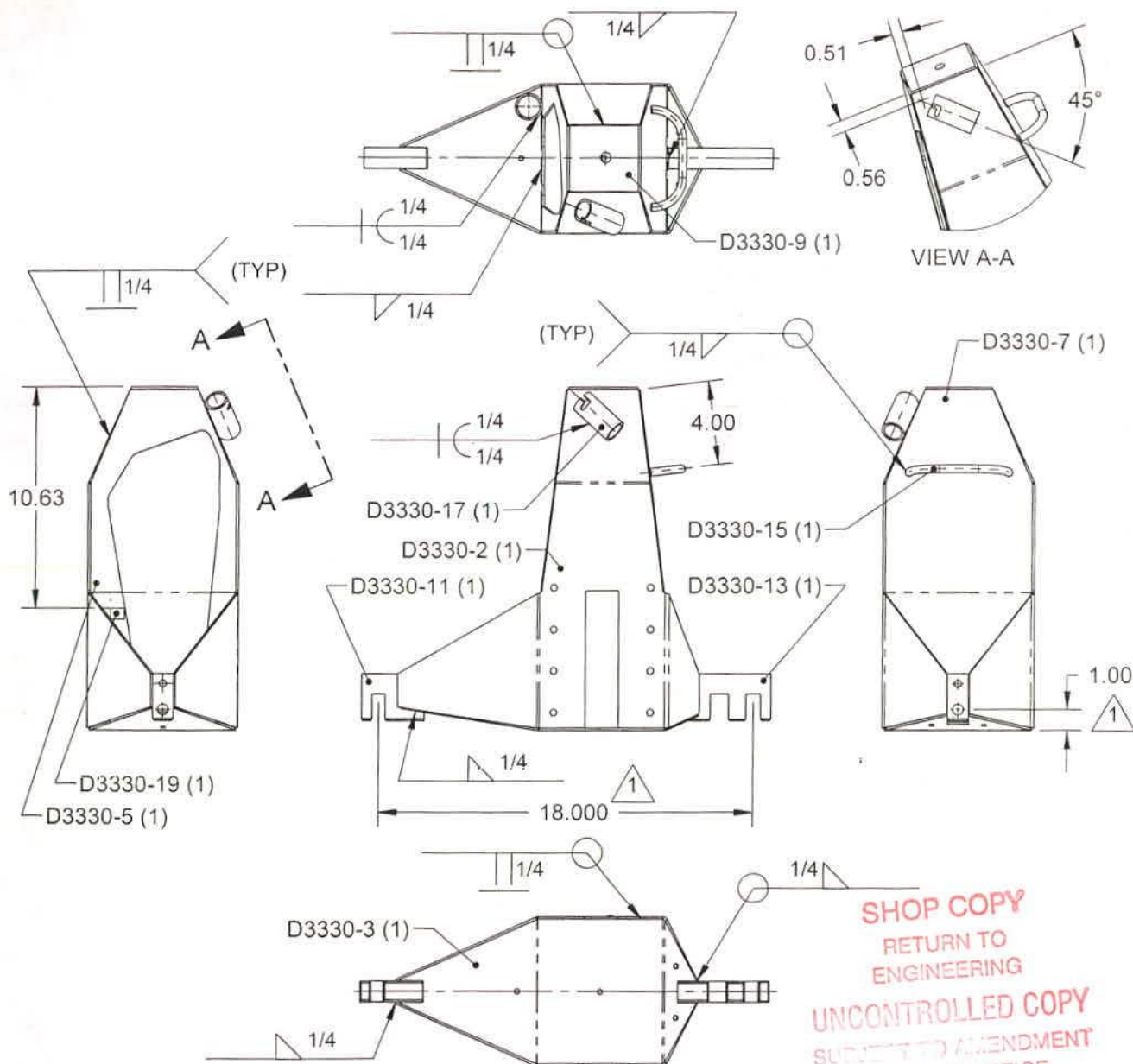
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED	DRAWING NO. D3330	REV. A SHEET 1 OF 9
DATE 04.12.16		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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WORK ORDER
NO. 22248
PRELIMINARY ISSUE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022248
Project Name : D3330-041
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3330-041
Description : Frame Weldment
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 01-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00